

Date: Thursday, 17/08/2006 3:31:31 PM
User: Linda Lacelle

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG STEP ASSEMBLY HIGH SKID LH
Job Number	: 28235		
Estimate Number	: 10270	Part Number	: D350591311
P.O. Number	: N/A	Drawing Number	: D3272 REV A
This Issue	: 17/08/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: N/A	Material	: N/A
Previous Run	: 27891	Due Date	: 25/09/2006
Written By	: <u>W</u>	Qty:	10 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	: Est Rev:A 04.03.22 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

2.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2622-120	Extrusion	328215

DE 06-10-14 10

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

1 E 06-10-14 10

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

1 E 06-10-16 10

3-Deburr

1 E 06-10-16 10

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

1 E 06-10-17 10

Date: Thursday, 17/08/2006 3:31:31 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 28235

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate

328270

FE. 06.10.23 10

6.0

D32191

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support

328271

FE. 06.10.23 10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

M19612
M18838

3-Grind End Plate flush

FE. 06.10.23 10

FE. 06.10.25 10

FE. 06.10.26 10

8.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 9

FC 06/10/30 (10)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 11 09 (10)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 06/11/10 (10)

Date: Thursday, 17/08/2006 3:31:31 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 28235

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3065-041 Step Leg Assy B27590

LE 06-11-15 10

12.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3066-1 Spacer B28940 = 7
B29234 = 13

LE 06-11-15 10

13.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet M101649

LE 06-11-15 10

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

LE 06-11-15 10

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20-11-15 (10)

16.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate B28270

2

Date: Thursday, 17/08/2006 3:31:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 28235

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M19838

4-Grind End Plate flush

06-11-15 FF (6)

FE. 06.11.15 10

FE. 06.11.15 10

FE. 06.11.15 10

FE. 06.11.16 10

18.0

QC5/9

WELD INSPECTION



Comment: Inspect work & Weld to Current - Check dimension 108.93" & 3.375" as per Dwg D3272

FE. 11.16 (10) 06/11/16

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

touch up alodine

YFC 06/11/16

X10

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YFC 06/11/20 x2

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

FC

06 11 20 x2

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

AB 06/11/20 (2)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Date: Thursday, 17/08/2006 3:31:32 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 28235

Part Number: D350591311

Job Number:



Seq. #: Machine Or Operation:

Description :

24.0 D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 D2230-3 Mounting Lug 28248 86

25.0 D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 D2618 Bushing 28248 44

26.0 D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 D2856-400-720 Abrasion Strip 28258 (2)

27.0 D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 D3235-1 Mounting Lug 328272 -4x

28.0 D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 1 D3278-041 Support Assembly 28278 2
✓ 1 D3272-041(ref) Step Assembly 28235

Date: Thursday, 17/08/2006 3:31:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 28235

Part Number: D350591311

Job Number:



Seq. #: Machine Or Operation:

Description :

29.0 AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

✓ Qty Part Number Description Batch

2 AN3-35A Bolt M101723

30.0 AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

✓ Qty Part Number Description Batch

8 AN4-13A Bolt M102380 16x

31.0 AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

→ ✓ Qty Part Number Description Batch

2 AN5-36A Bolt M19073 4x P20 SORT1

32.0 AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

✓ Qty Part Number Description Batch

4 AN960JD10 Washer M100743 8x

33.0 AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

✓ Qty Part Number Description Batch

16 AN960JD416 Washer M102339 32

Date: Thursday, 17/08/2006 3:31:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 28235

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN960JD516 Washer M120564 8X

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 MS21042L3 Nut (or -3) M101917 4X

36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 MS21042L4 Nut (or -4) M19185 16X

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 MS21042L5 Nut (or -5) M102271 4X

4/11/21 (2)

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

04/11/21 (2)

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location:

16VB 4/11/21 (2)

Date: Thursday, 17/08/2006 3:31:32 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 28235

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Doc 11/21

Job Completion



u Doc 11-21



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. A
				D3272	SHEET 1 OF 2
DATE				TITLE	SCALE
04.03.01				STEP ASSEMBLY, HI LONG	NTS
A	04.03.01			NEW ISSUE	

RELEASED
04.04.05

Part No.	Description	QTY -041	QTY -042
D3272-041	Step Assembly, High Long (LH)	X	
D3272-042	Step Assembly, High Long (RH)		X
D2622-120	STEP EXTRUSION	1	1
D3219-1	SUPPORT	2	2
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

REFERENCE ONLY

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Date: Thursday, 17/08/2006 3:31:31 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG STEP ASSEMBLY HIGH SKID LH
Job Number	: 28235		
Estimate Number	: 10270		
P.O. Number	:	Part Number	: D350591311
This Issue	: 17/08/2006 S.O. No. :	Drawing Number	: D3272 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 27891	Material	:
Written By	: <u>W</u>	Due Date	: 25/09/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	: Est Rev:A 04.03.22 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

06.09.06 HJ

2.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2622-120	Extrusion	

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

REFERENCE ONLY